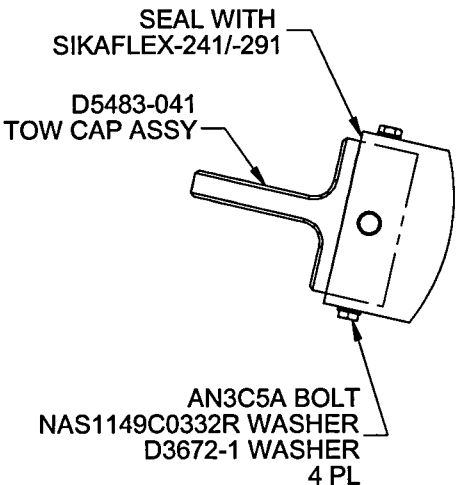


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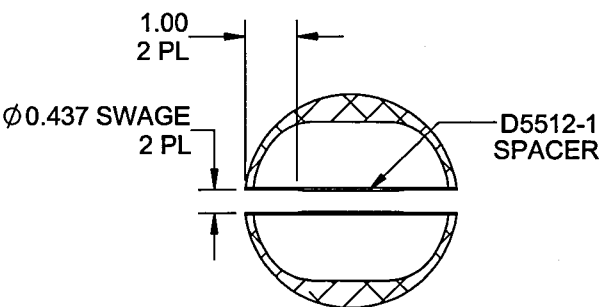
2018 AUG 16  
ECN 18-736

B	CHANGE HOLE SIZE TO IMPROVE OFF-AXIS SWAGING IN SHEETS 5 AND 6 (NCR18-6741). PICTORIAL UPDATE DUE TO CHANGES IN D5483-1.	NO	18.02.05
A	NEW ISSUE	NO	17.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	NO		
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 1 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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D5425-041 FLOAT SKIDTUBE ASSY

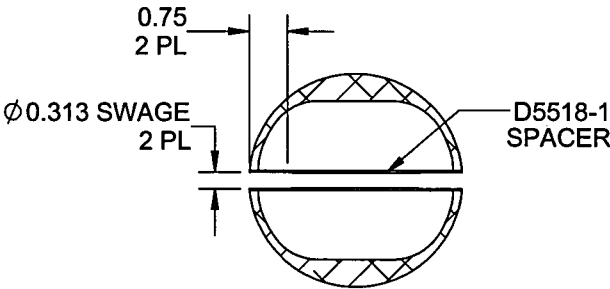


DETAIL A  
SCALE 4X



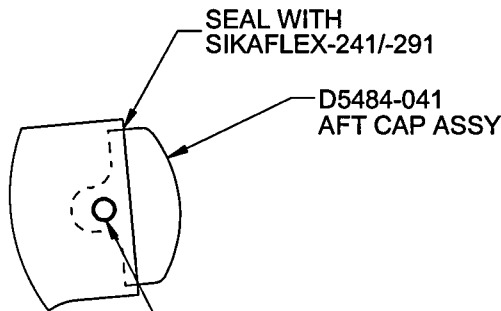
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR  $\phi 0.508$  HOLES ONLY:  
1. WET INSTALL D5512-1 SPACER PER QSI 002  
2. SWAGE TO  $\phi 0.437 \times 1.00$  DEEP PER QSI 002  
3. TRIM / GRIND FLUSH PER QSI 002

SECTION C-C  
SCALE 4X  
12 PL



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR  $\phi 0.377$  HOLES ONLY:  
1. INSERT D5518-1 SPACER  
2. SWAGE TO  $\phi 0.313 \times 0.75$  DEEP PER QSI 002  
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B  
SCALE 4X  
37 PL



DETAIL D  
SCALE 4X

RELEASED

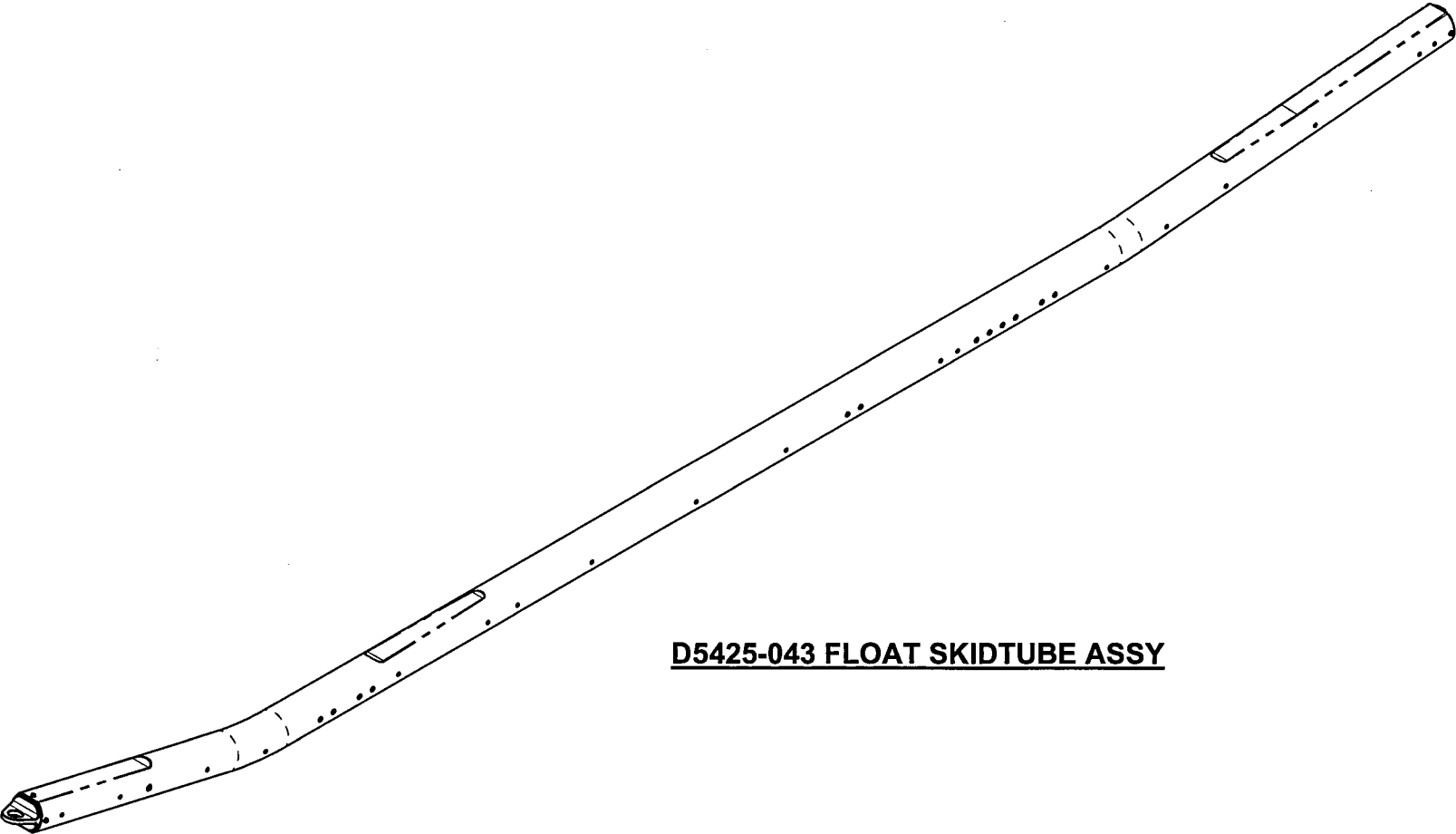
2018 AUG 16

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME PER DART QSI 005 4.2.1.3.3  
PAINT PER DART QSI 005 4.2.2.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 54.5lbs
  - 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

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DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 2 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS- <del>   </del>	412 FLOAT SKIDTUBE	NTS
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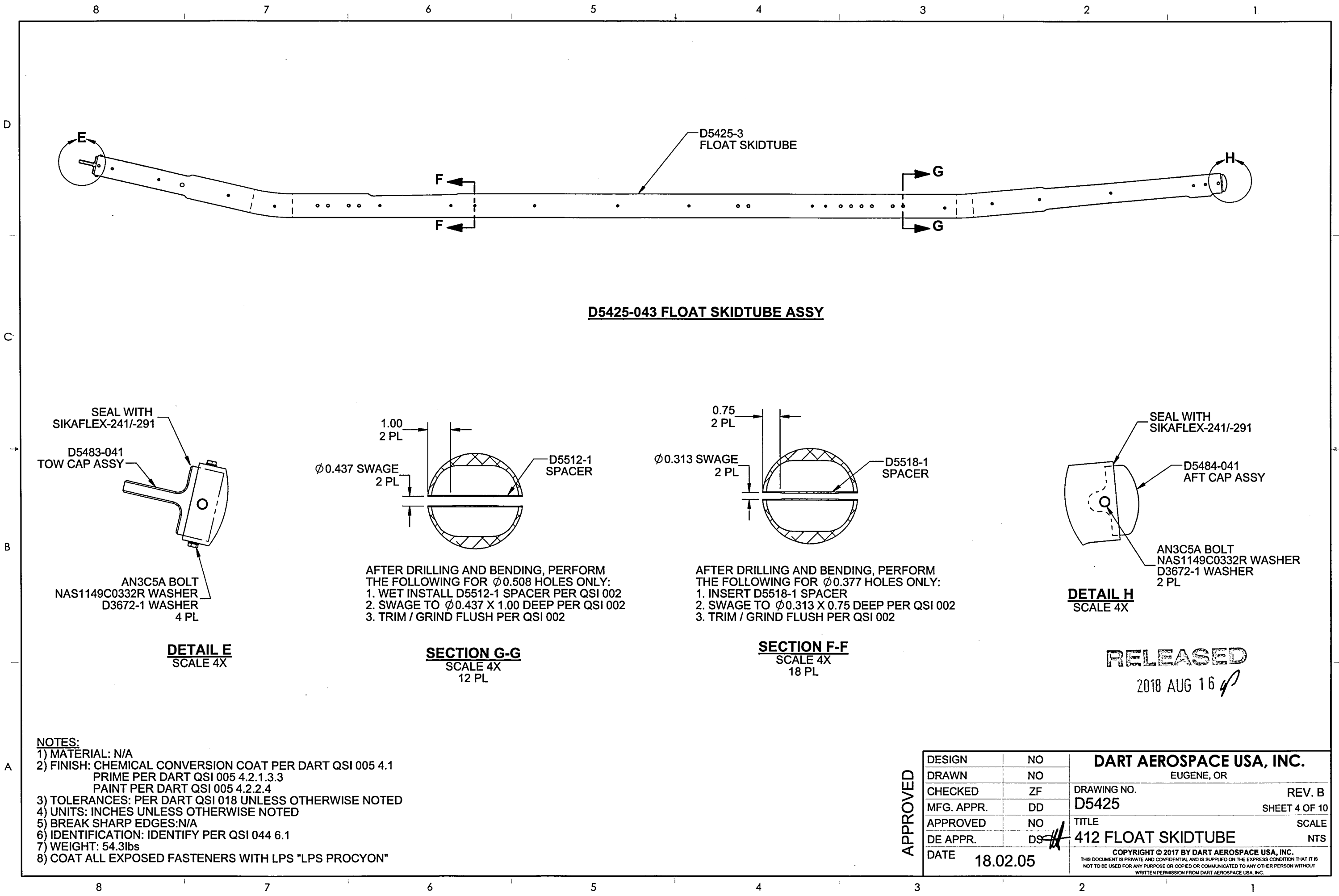
QTY -043	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
18	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER



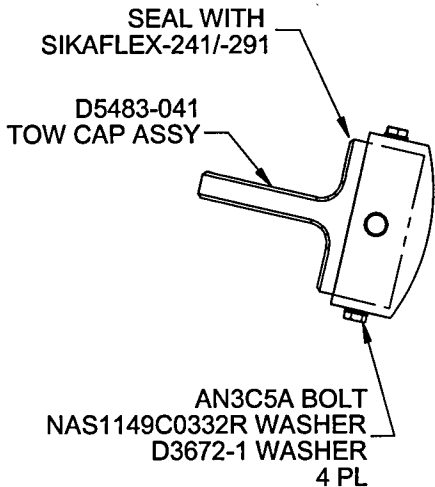
D5425-043 FLOAT SKIDTUBE ASSY

RELEASED  
2018 AUG 16

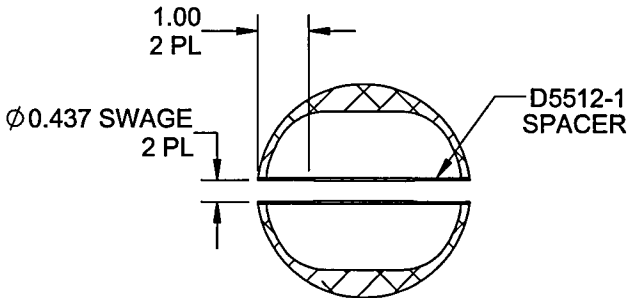
APPROVED	DESIGN	NO	DART AEROSPACE USA, INC.	
	DRAWN	NO	EUGENE, OR	
	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 3 OF 10
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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**D5425-043 FLOAT SKIDTUBE ASSY**

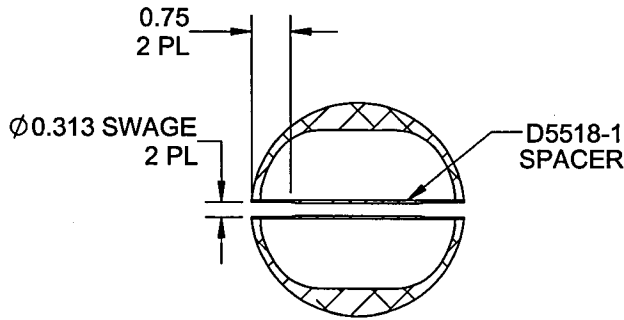


**DETAIL E**  
SCALE 4X



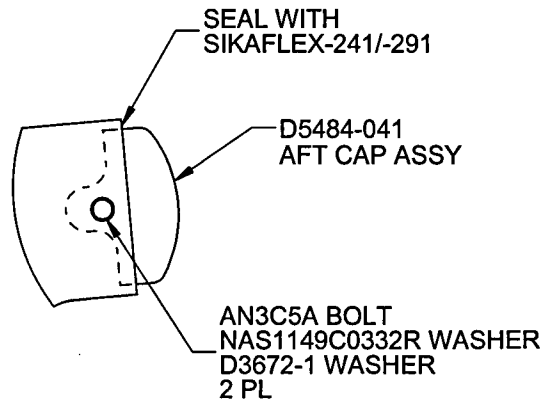
AFTER DRILLING AND BENDING, PERFORM  
THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. WET INSTALL D5512-1 SPACER PER QSI 002  
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002  
3. TRIM / GRIND FLUSH PER QSI 002

**SECTION G-G**  
SCALE 4X  
12 PL



AFTER DRILLING AND BENDING, PERFORM  
THE FOLLOWING FOR Ø0.377 HOLES ONLY:  
1. INSERT D5518-1 SPACER  
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002  
3. TRIM / GRIND FLUSH PER QSI 002

**SECTION F-F**  
SCALE 4X  
18 PL



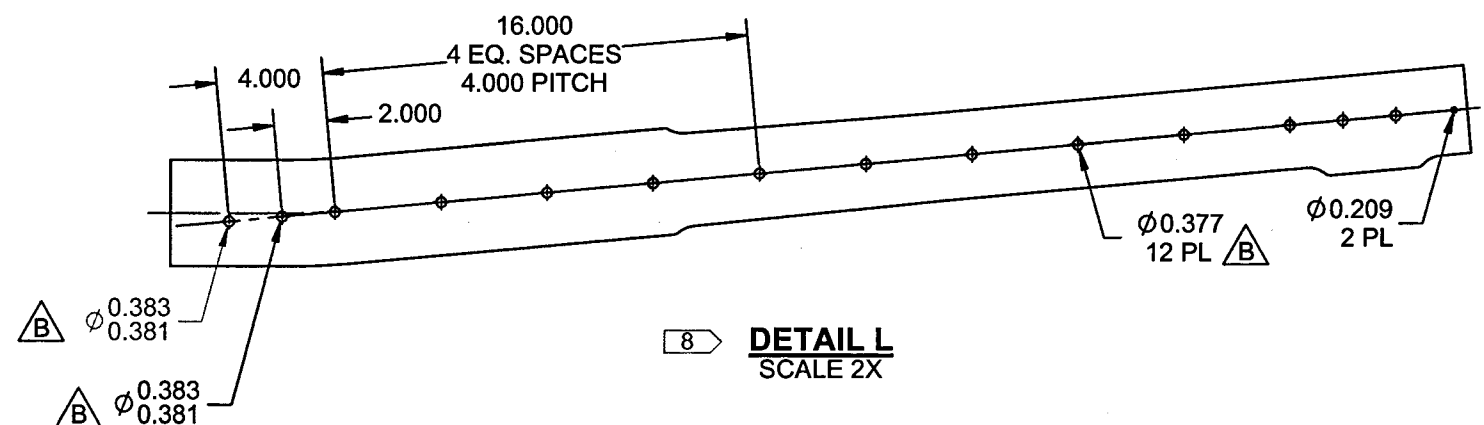
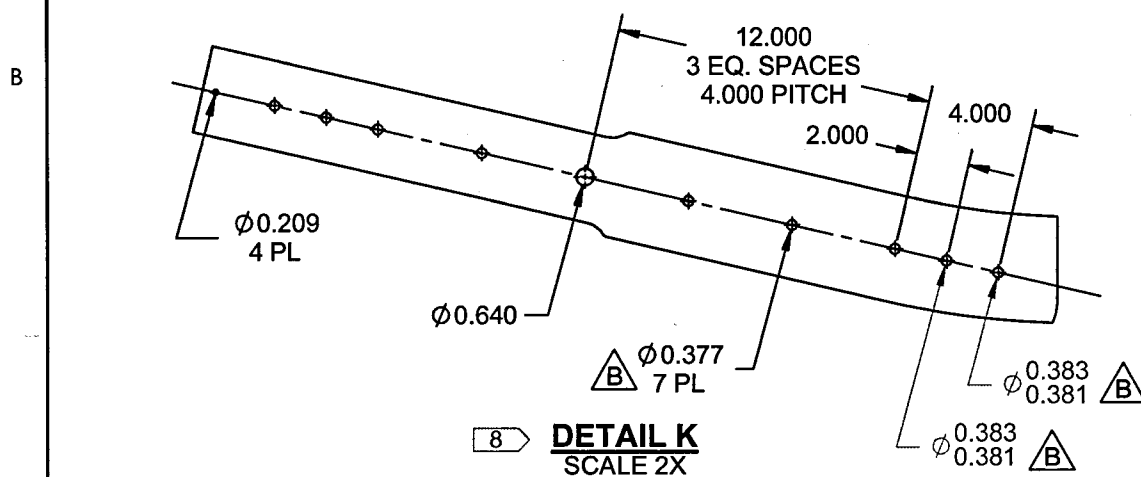
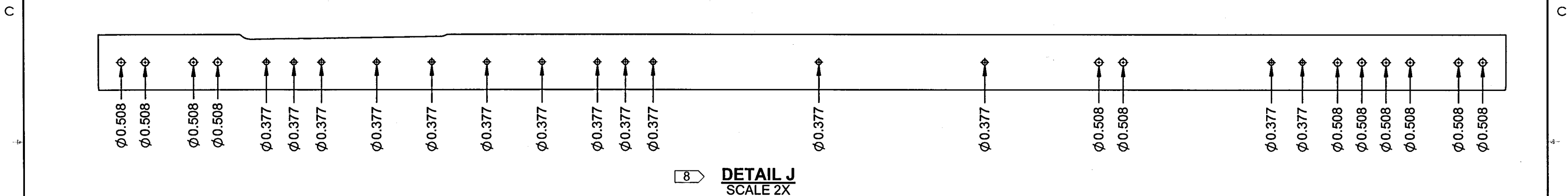
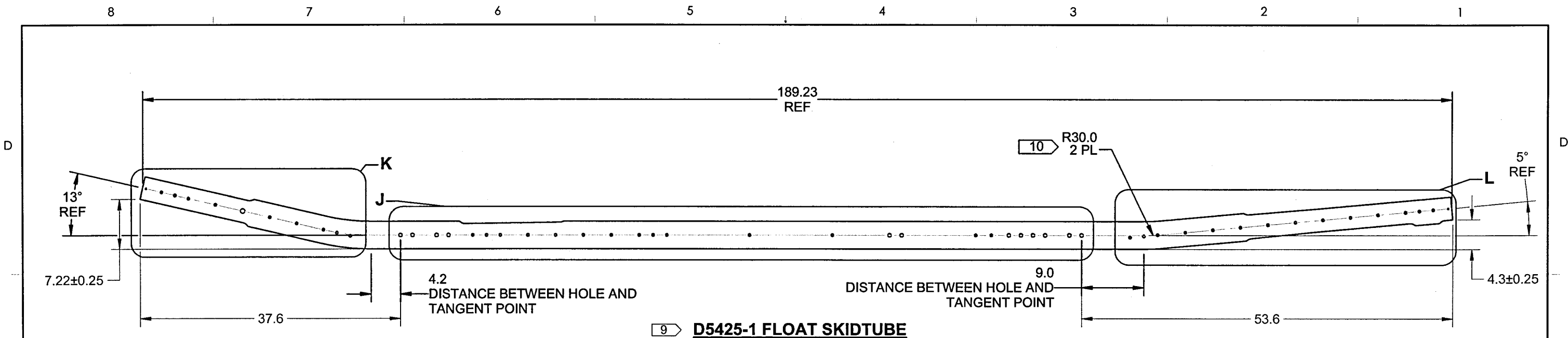
**DETAIL H**  
SCALE 4X

**RELEASED**  
2018 AUG 16

- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME PER DART QSI 005 4.2.1.3.3  
PAINT PER DART QSI 005 4.2.2.4  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
7) WEIGHT: 54.3lbs  
8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

APPROVED

DESIGN	NO	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	<b>D5425</b>	SHEET 4 OF 10
APPROVED	NO	TITLE	SCALE
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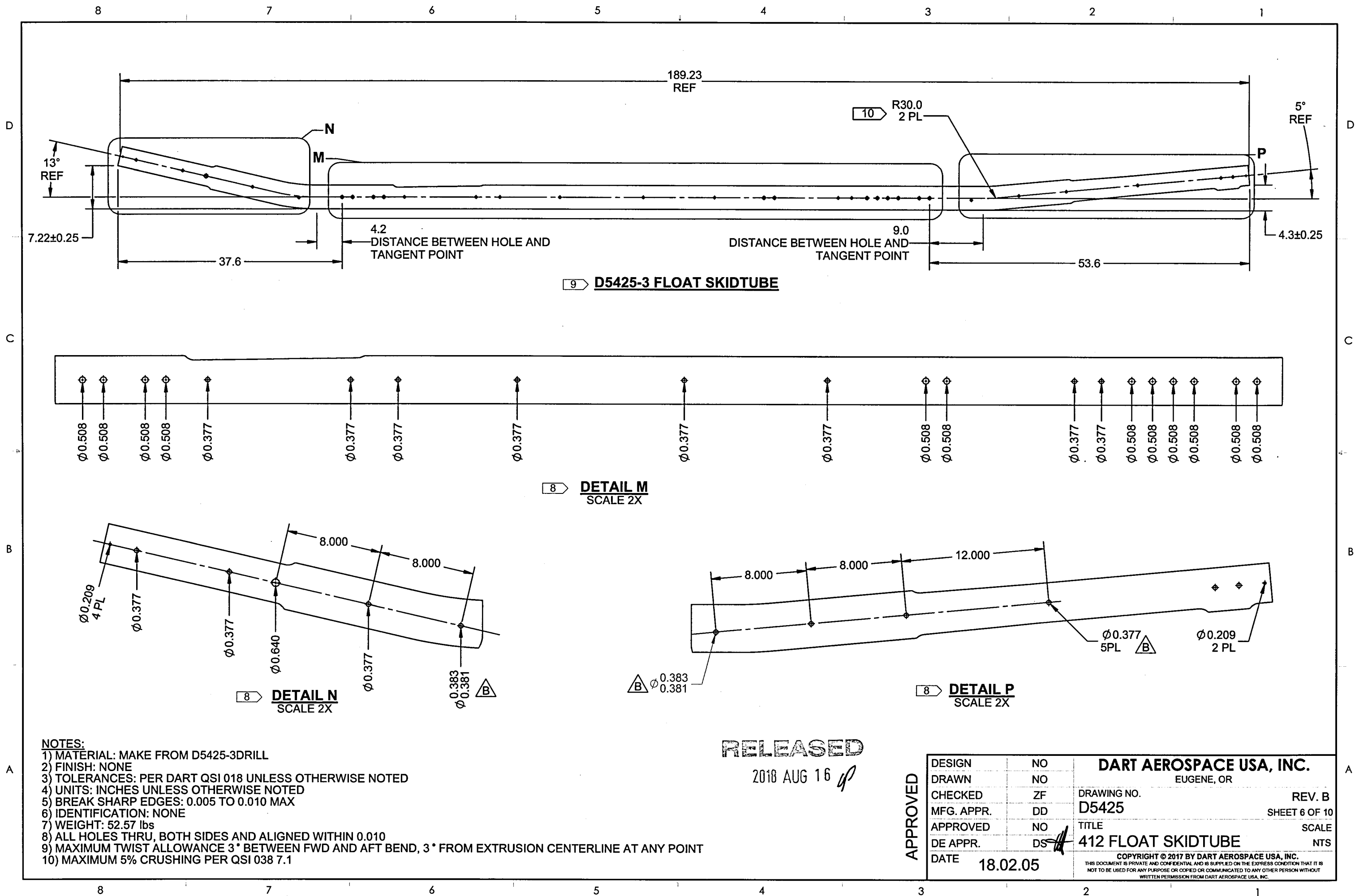


- NOTES:
- 1) MATERIAL: MAKE FROM D5425-1DRILL
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 52.57 lbs
  - 8) ALL CENTERLINE HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
  - 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM EXTRUSION CENTERLINE AT ANY POINT
  - 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

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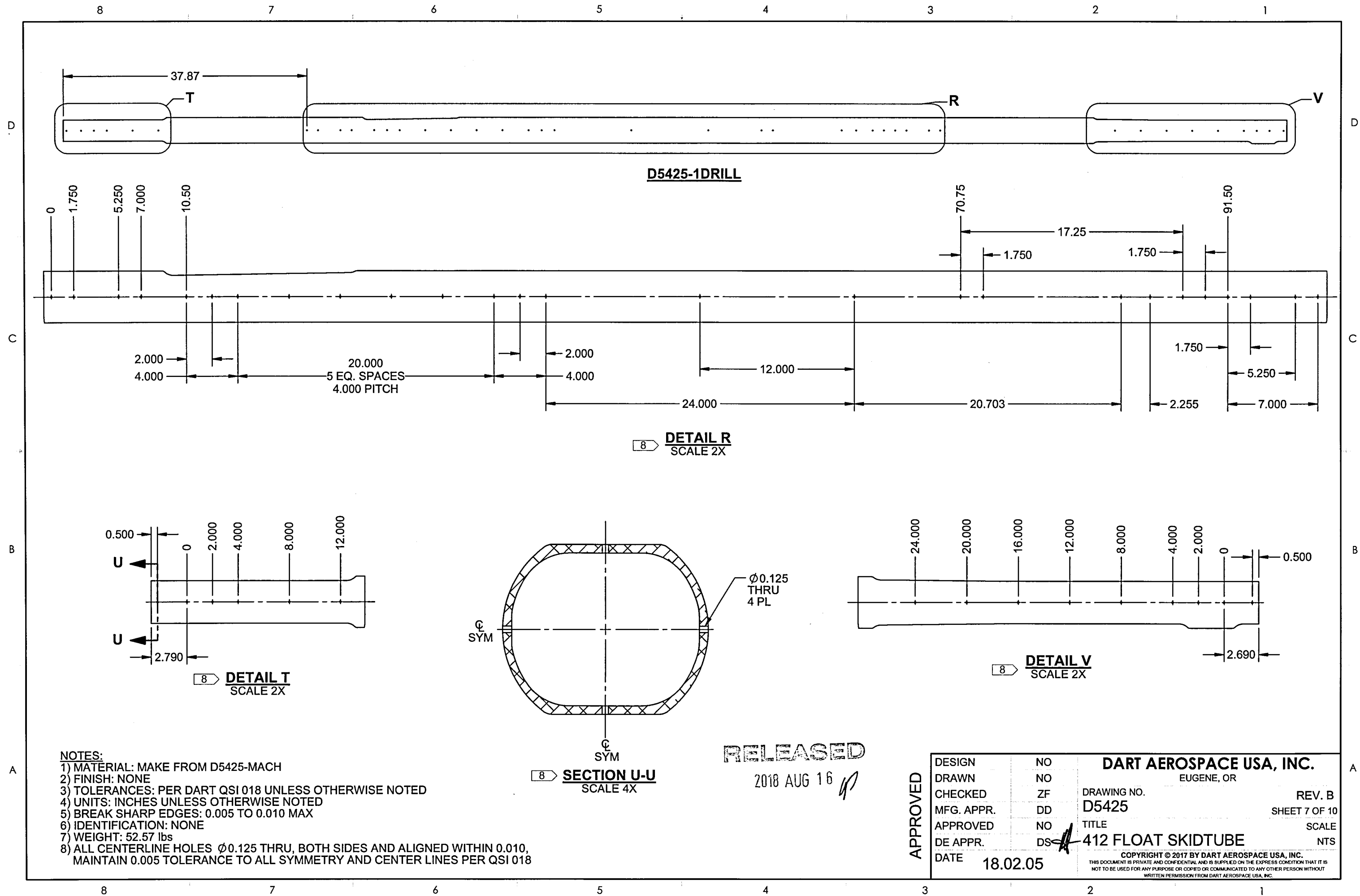
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 5 OF 10
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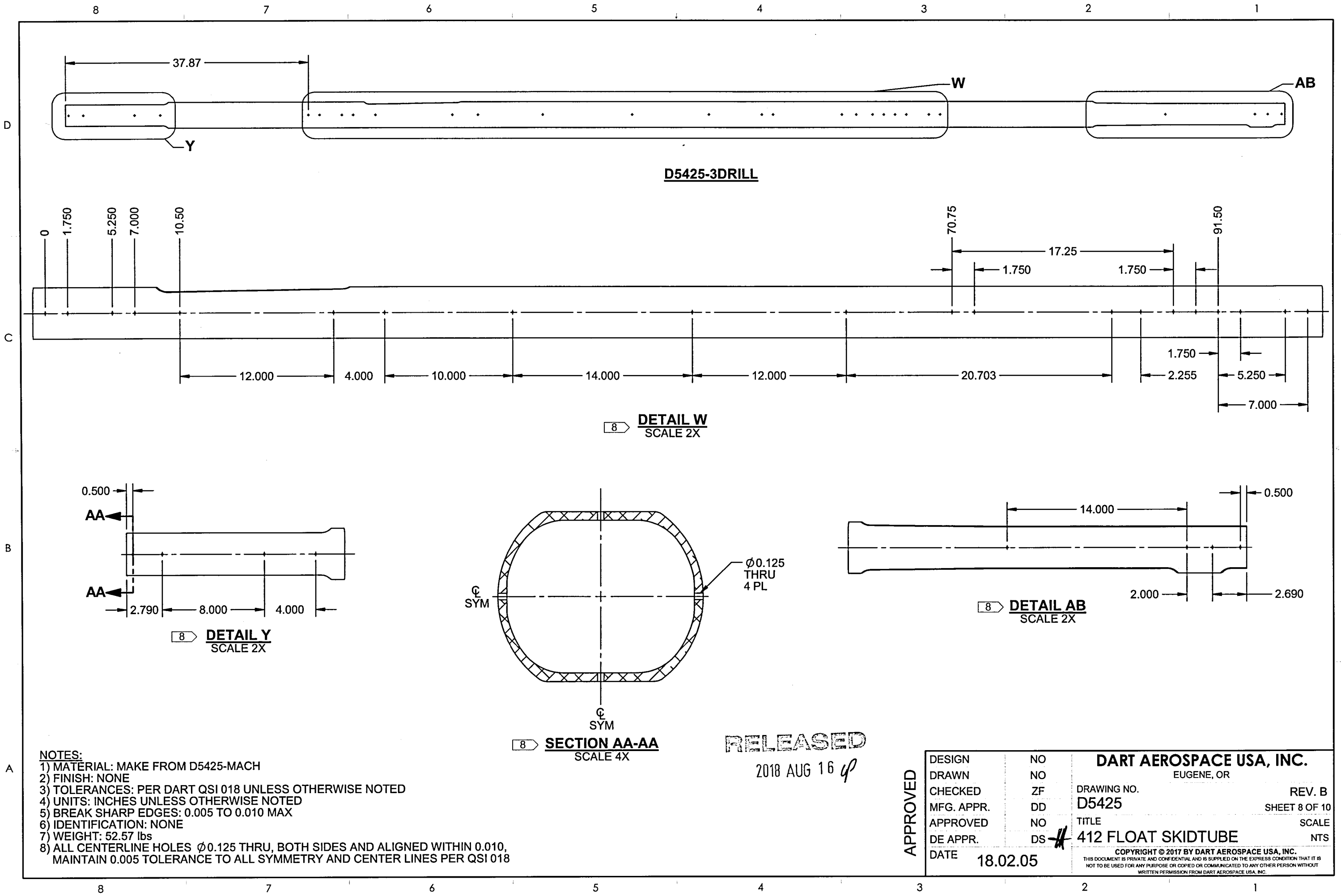


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CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 6 OF 10
APPROVED	NO	TITLE	SCALE
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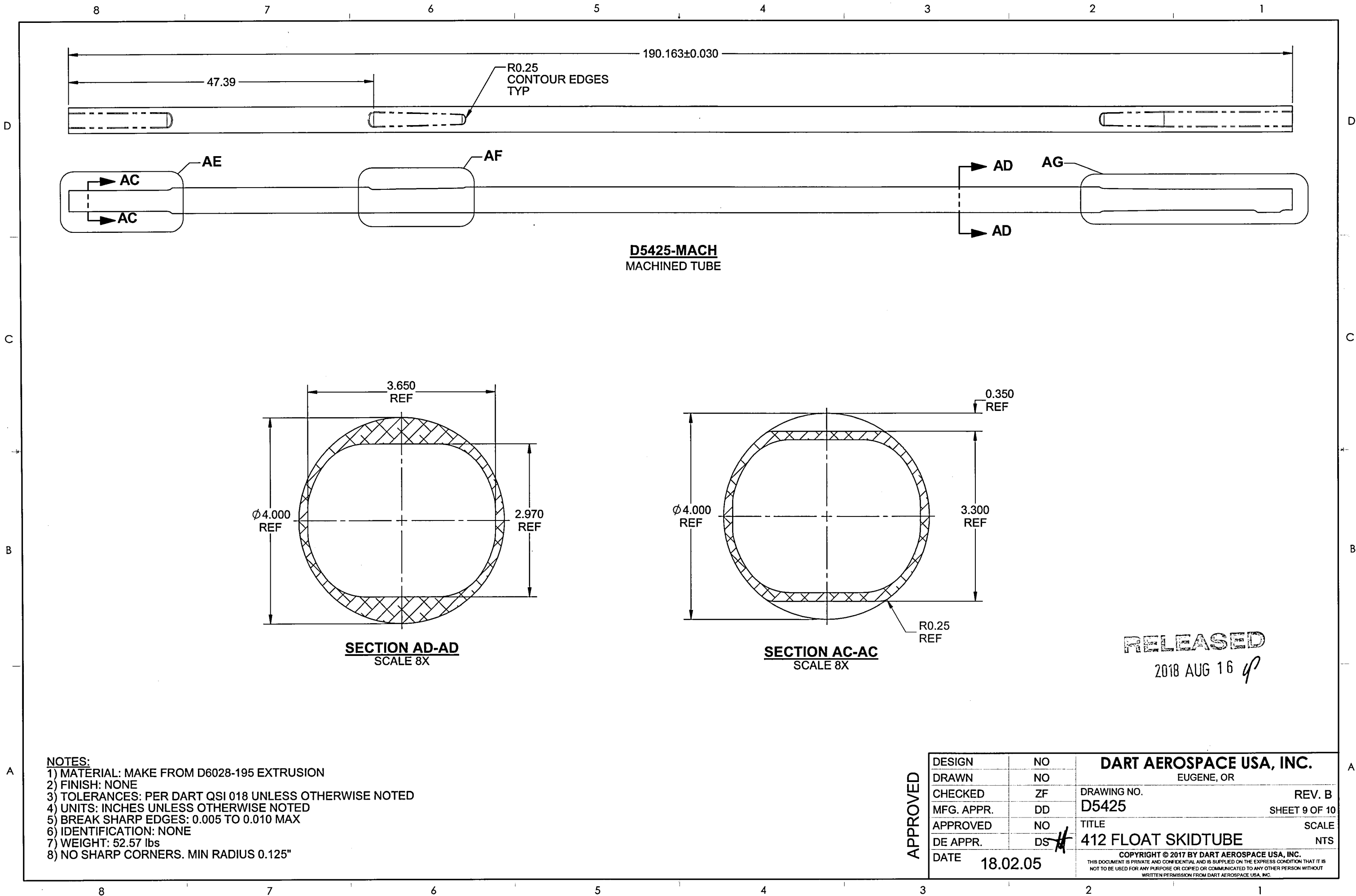


NOTES:  
1) MATERIAL: MAKE FROM D5425-MACH  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 52.57 lbs  
8) ALL CENTERLINE HOLES  $\phi 0.125$  THRU, BOTH SIDES AND ALIGNED WITHIN 0.010, MAINTAIN 0.005 TOLERANCE TO ALL SYMMETRY AND CENTER LINES PER QSI 018

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	DRAWN	NO	EUGENE, OR	
	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 8 OF 10
	APPROVED	NO	TITLE	SCALE
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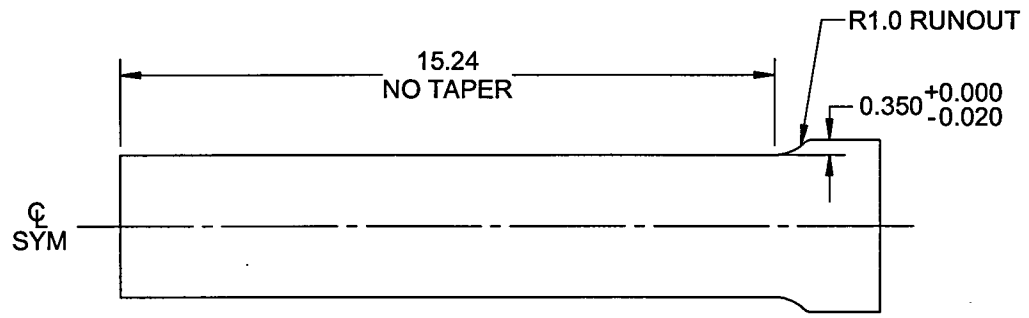
- NOTES:
- 1) MATERIAL: MAKE FROM D6028-195 EXTRUSION
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 52.57 lbs
  - 8) NO SHARP CORNERS. MIN RADIUS 0.125"

APPROVED

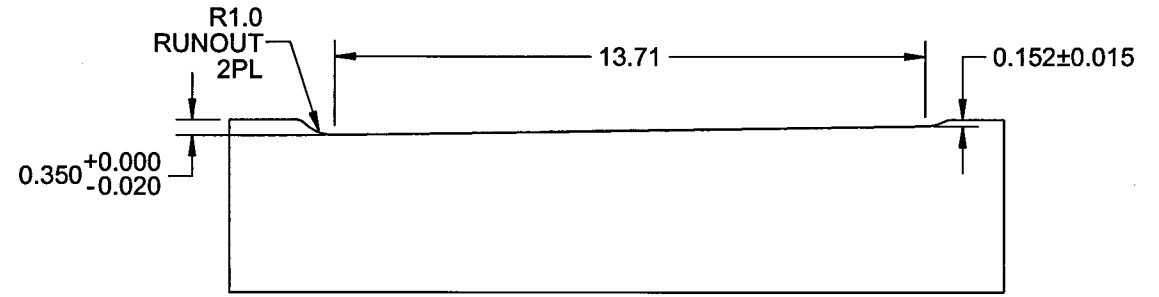
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 9 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS <i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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8 7 6 5 4 3 2 1

D

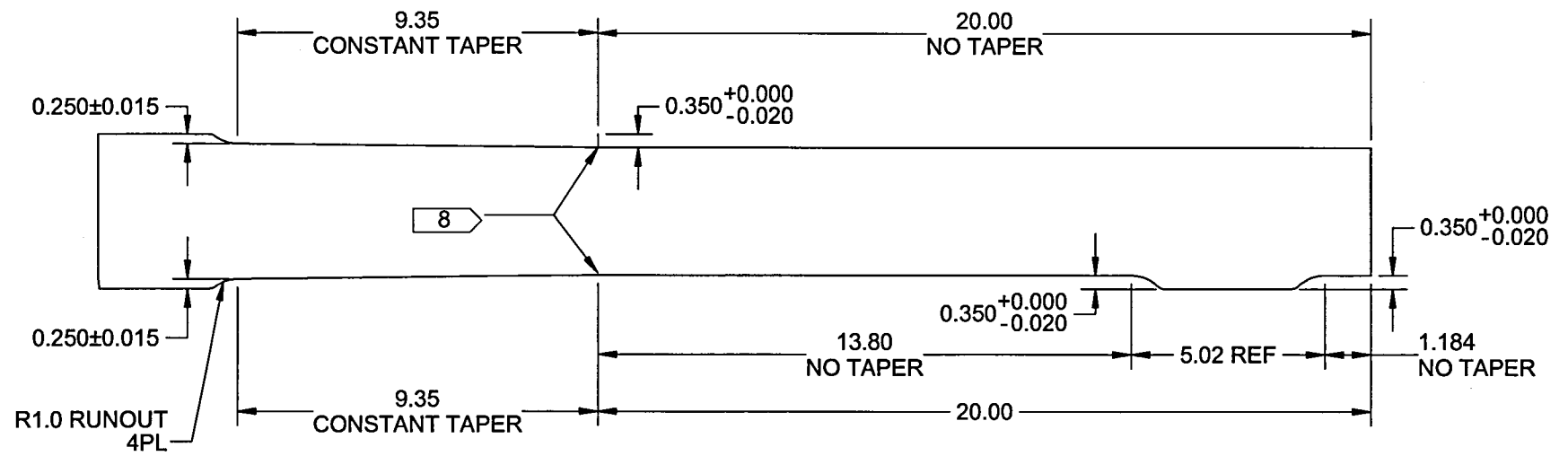


**DETAIL AE**  
SCALE 3X



**DETAIL AF**  
SCALE 3X

C



**DETAIL AG**  
SCALE 3X

B

B

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2018 AUG 16 *up*

A

A

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CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	<b>D5425</b>	SHEET 10 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	<b>412 FLOAT SKIDTUBE</b>	NTS
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8 7 6 5 4 3 2 1